Qty:

20 Um:

Each

Friday, 01/08/2008 10:42:28 AM

User:

Julie Lecocq

### **Process Sheet**

**Drawing Name** 

**Part Number** 

Material

**Due Date** 

**Drawing Number** 

**Project Number** 

**Drawing Revision** 

: LUG

: D22491

: N/A

: E

. D2249 REV. E

: 10/08/2008

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 40893A

**Estimate Number** 

: 10839

P.O. Number

**Previous Run** 

Written By

: 01/08/2008

This Issue : NC

Prsht Rev. First Issue

: //

: 40486A

Type

S.O. No. :

: SMALL /MED FAB

Checked & Approved By

Comment

Added Step 9 KJ/RF

Now on Waterjet 07-03-08 JLM Est Rev:E

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

1.0

M304S16GA

304/316 Sheet .063



Comment: Qty.:

0.0903 sf(s)/Unit

Total:

1.8060 sf(s)

304/316 .063 Sheet

Batch:\_106090

2.0

WATER JET

FLOW WATER JET



**Comment: FLOW WATER JET** 

1-Cut as per Dwg D2249

Dwg Rev:\_\_ Prog Rev:\_\_ AB 8-8-8

2-Deburr if necessary

6-8-12 Ob

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK

Comment: SECOND CHECK

PACKAGING RESOURCE #1



PACKAGING 1 5.0



Comment: PACKAGING RESOURCE #1

Identify and Stock Location:

exenter

# **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
		·								

Part No:	PAR #:	_ Fault Category:	NCR: Yes	No <b>DQA</b> :	Date:	
			QA: N	/C Closed:	Date:	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
		Description of NC		Corrective Action Section B	3	Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
		385						
		4						

NOTE: Date & initial all entries

Date: Úser: Friday, 01/08/2008 10:42:28 AM

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

**Drawing Name: LUG** 

Job Number: 40893A

Part Number: D22491

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE





Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Job Completion



# **Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				•			
	1		<u></u>	<u> </u>			

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	_ Date:
			QA: N/C Closed:	_ Date:

NCR: WORK ORDER NON-CONFORMANCE (NCR				CE (NCR)				
		Description of NC		Corrective Action Section E		Verification	Approval	Approva
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspecto
							4	
i.								

NOTE: Date & initial all entries



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94.06.20			#	APPROVED	<u> </u>	DRAWN BY
NEW ISSUE	FITTING	TITLE SCALE	D2249 SHEET 1 OF 4	DRAWING NO. REV. E	HAWKESBURY, ONTARIO, CANADA	DART AEROSPACE LTD

Ö

95.12.14 95.11.30

DIMENSION CHANGE

DIMENSION

CHANGE

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98.04.30

Ø0.261 WAS Ø0.257 REMOVED DUPLICATE

(TSR A179) DIMENSIONS

99.09.20

ADDED GUSSET

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02249-1 (2)	2.00 — — — — — — — — — — — — — — — — — —			WELD USING TOOL DT8209
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D2249-5 (REF)

D2249-041 ASSEMBLY

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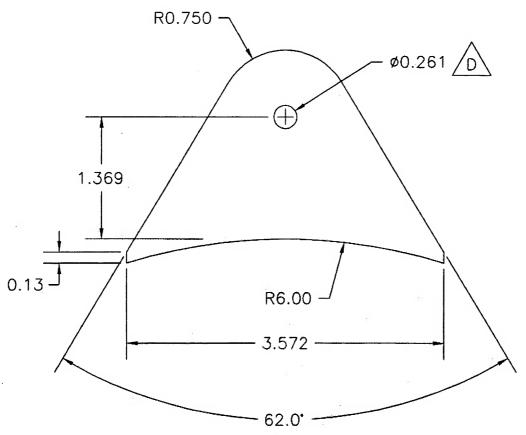
MATERIAL: AISI 304/316 SS, 0.063 THICK WELD PER DART QSI 004 FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 ALL DIMENSIONS ARE IN INCHES TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE SPECIFIED





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D2249-1 LUG

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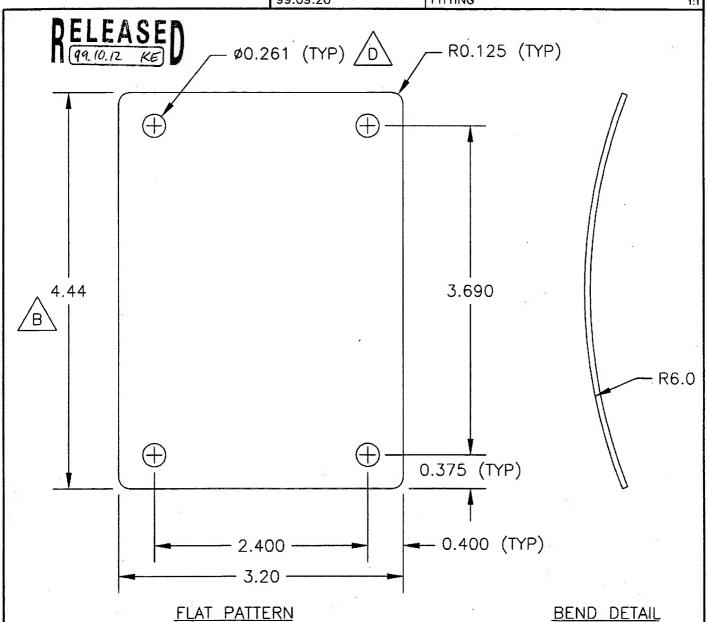
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D2249-3 BASE PLATE

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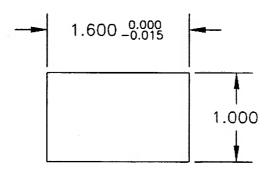
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D2249-5 GUSSET

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TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

-DART-AEROSPACE LTD	Work Order: 40893 A
Description: Lu6	Part Number: 10 2244-1
Inspection Dwg: D3249-1 Rev: E	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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3,572	4/010	3,568	$\mathcal{A}$			
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	33.00					
					9.439	
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	(2)					
L						

Measured by: 18	Audited by:	Prototype Approval:	N/	
Date: 8-8-8	Date: 04/08/12	Date:	12	

Rev	Date	Change	Revised by	Approved
Α		New Issue	KJ/JLM	